

Work Order ID 76194

76194

Page 1

November-07-11 1:28:02 PM

Item ID: D3065-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Leg Assembly Hi **14**
 Start Date: 07/11/2011 Start Qty: ~~12.00~~ ***12*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 12.00 ***12*** Customer:

Reference:

Approvals: Process Plan: M.C.3 Date: 11/11/08 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3065	Rev B

100		0.00
100	Small Fab	
Small Fab	Memo	0.00
Small Fab	Assemble as per Dwg D3065 and Identify as D3065-041	

EP 11/11/10 (14)

110	QC5- Inspect part completeness to step on W/O	0.00
110		
QC	Memo	0.00
Quality Control		

Sululo

(14)

120	Identify as per dwg & Stock Location: <u>11A</u>	0.00
120		
Packaging	Memo	0.00
Packaging		

11.11.12

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76194***76194***

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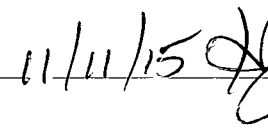
November-07-11 1:28:02 PM

Item ID: D3065-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Leg Assembly Hi
Start Date: 07/11/2011 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 21/11/2011 Req'd Qty: 12.00 ***12*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

11/11/15 
011-11-14
(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 76194

76194

Parent Item: D3065-041

D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPPKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3065-1 *D3065-1* Step Spacer		Manufactured	No			100	Each	45.0000	1	12			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				45					
				74497				45					
D3065-3 *D3065-3* Step Spacer		Manufactured	No			100	Each	29.0000	1	12			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				29					
				69827				1					
				73290				4					
				74498				24					
D3065-5 *D3065-5* Step Leg		Manufactured	No			100	Each	30.0000	2	24			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				30					
				67222				1					
				73289				19					
				74490				10					

**

**

**

B 75/53
(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 76194

76194

Parent Item: D3065-041

D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 12.00

Required Qty: 12.00

D3065-7 Manufactured No

100 Each

22.0000

1

12

D3065-7

Step Spacer

**

Location

Loc Qty

Loc Code

GA

22

73291

7

74499

15

MS20470AD4-4

Purchased No

100 Each

5,694.000

30

360

MS20470AD4-4

Rivet, Universal Head

**

Location

Loc Qty

Loc Code

ST

2220

119386

2220

ST139

78

117423

78

ST319

3396

116188

136

116391

66

118614

1194

119109

2000

ES 11/11/10

ES 11/11/10

420

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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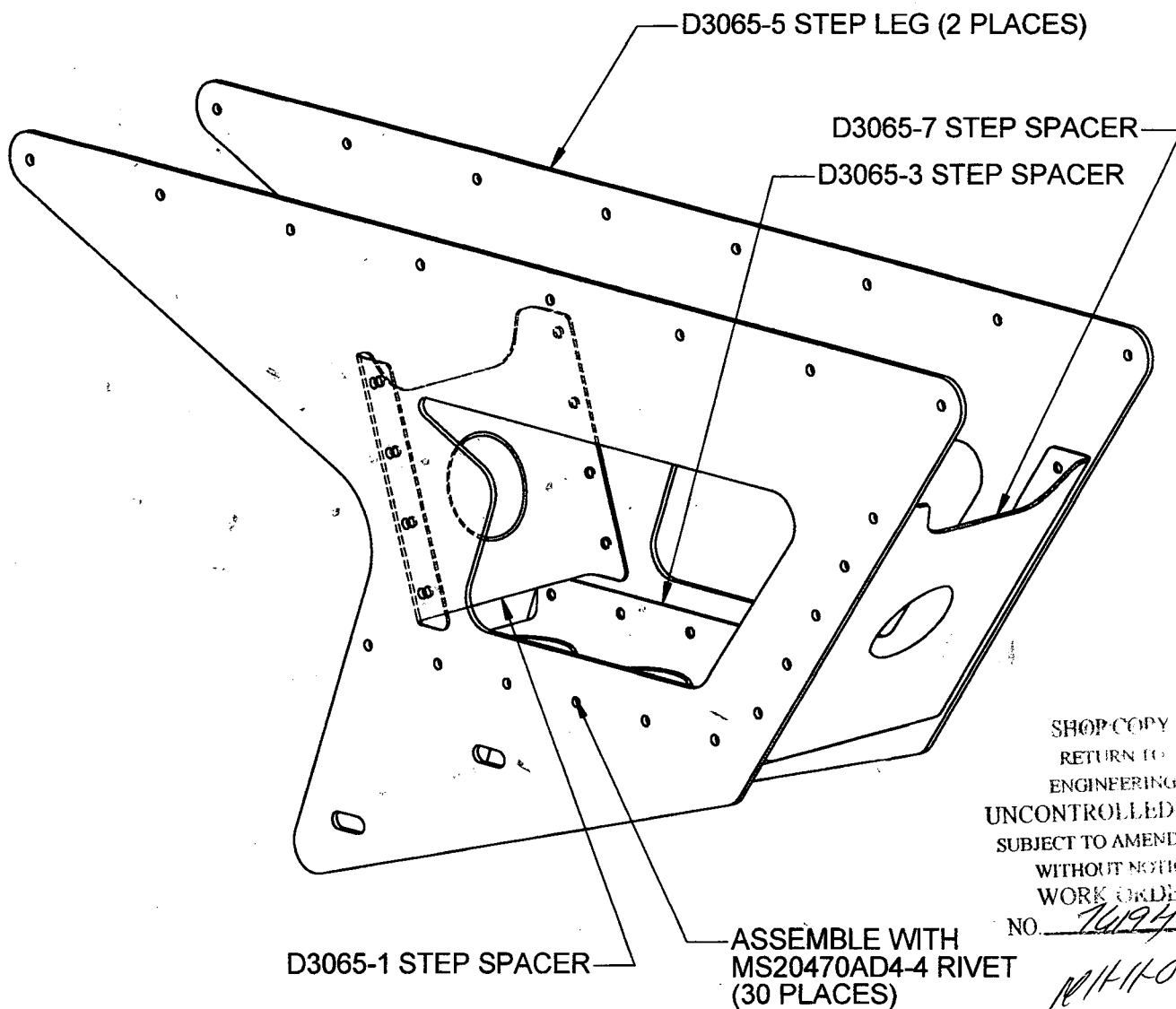
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *74194*

11/11/06

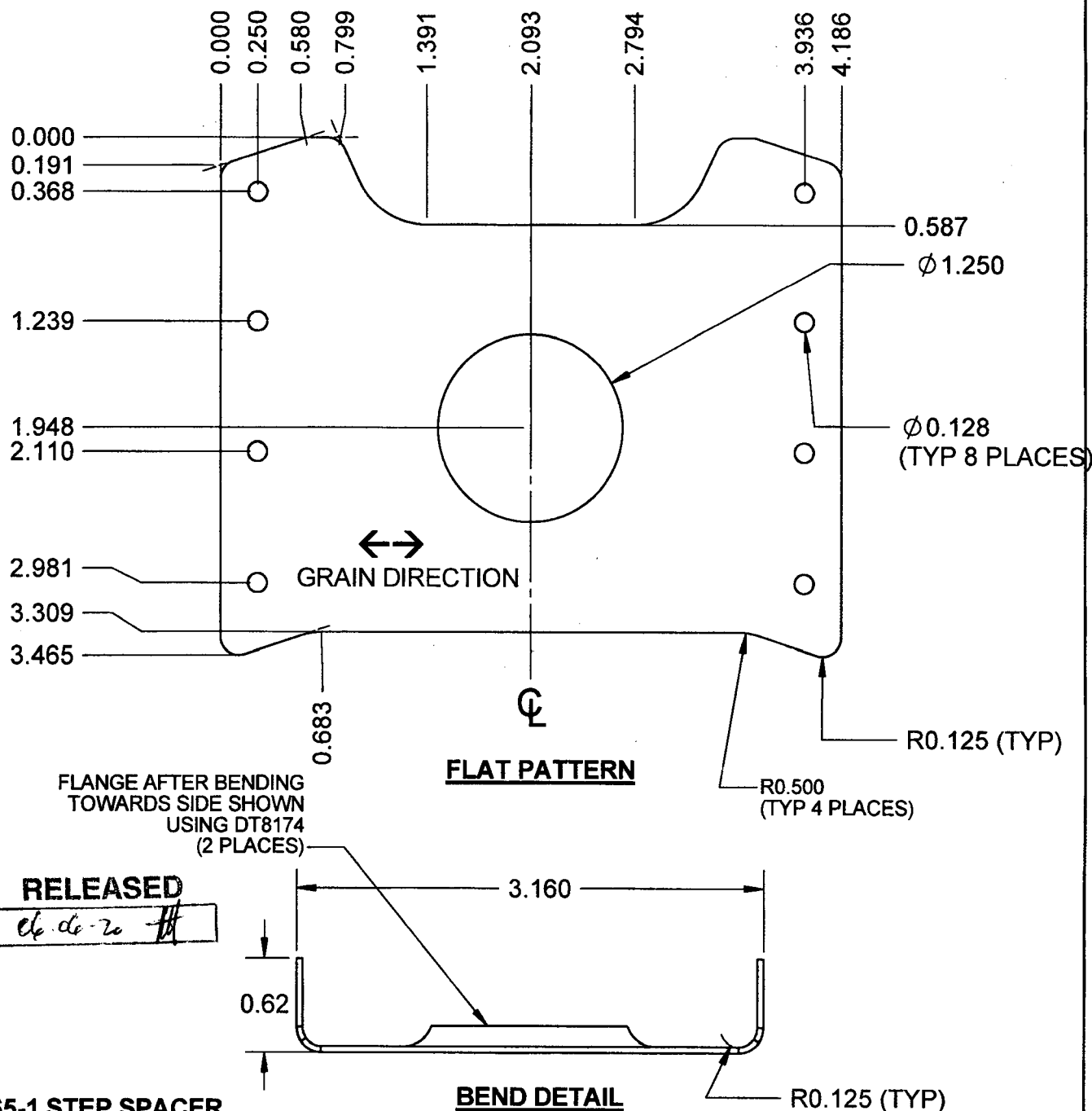
D3065-041 STEP LEG ASSEMBLY

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-1 STEP SPACER

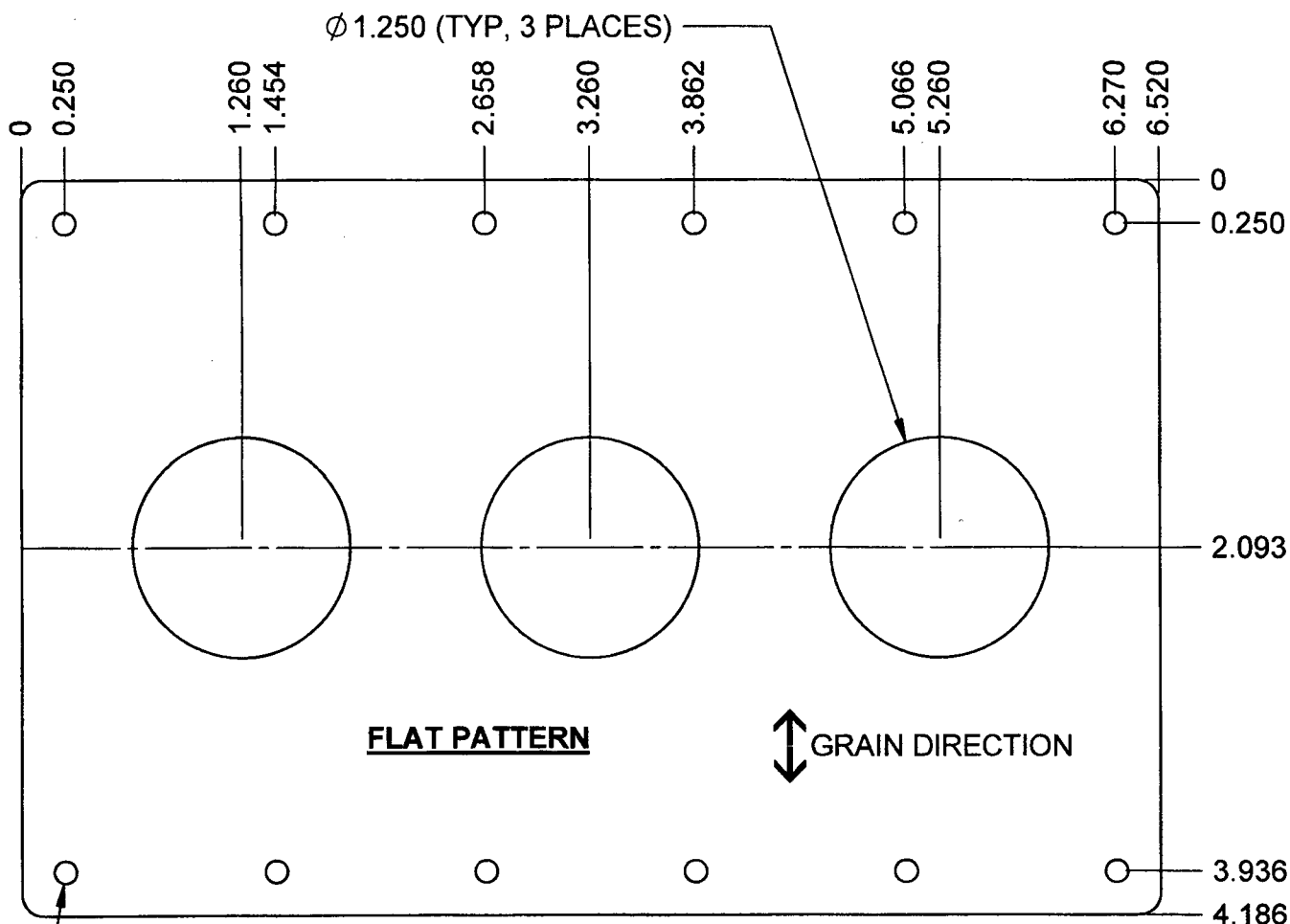
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

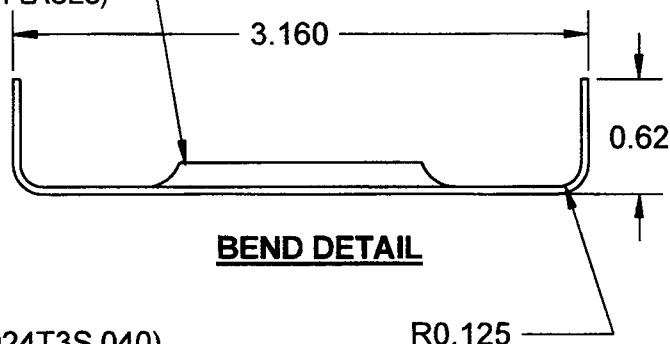


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06 Oct 20 *[Signature]*



D3065-3 STEP SPACER

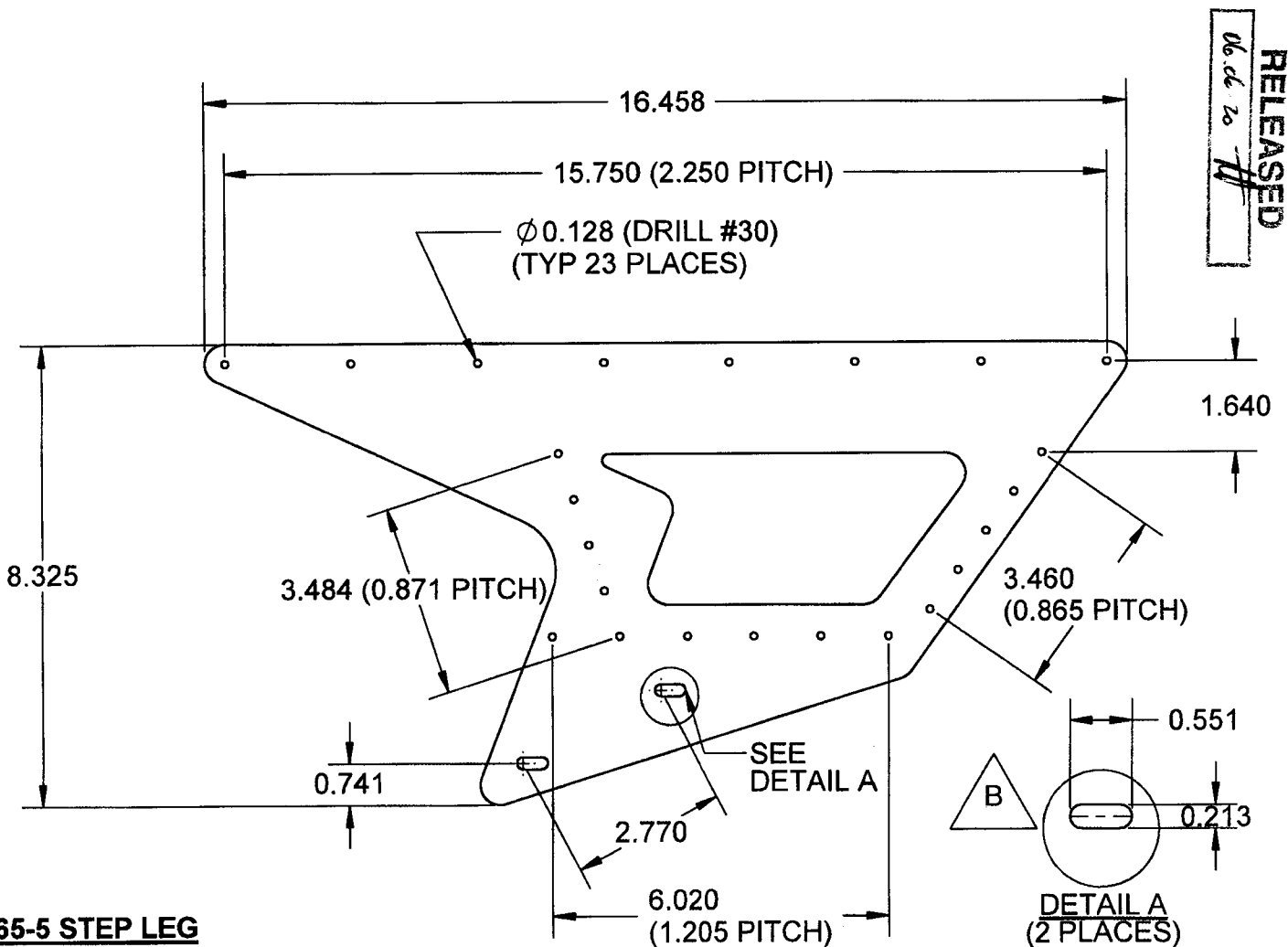
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CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA
DATE	06.05.23	DRAWING NO.	D3065	REV. B
		TITLE	STEP LEG ASSEMBLY	SHEET 4 OF 5
		SCALE	1:3	

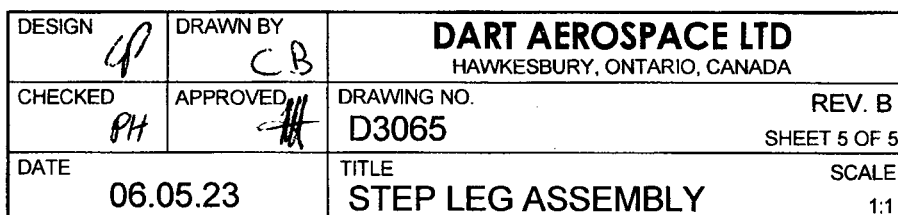


D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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